

Work Order ID 105509

August-08-13 7:54:28 AM

D2699

\*105509\*

Page 1

Item ID: D2699

B 105509

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Arm Lower Clevis

Start Date: 8/08/13

Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 8/09/13

Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2699	Rev B								

100

0.00

\*100\*

Waterjet

FLOW CNC Waterjet

Memo

CUT AS PER FILE

PROG REV: B

DWG REV: B

DEBURR

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Quality Control

Memo

0.00

26 0 13.08.10

26 0 13.08.10

P70



Work Order ID 105509

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Item ID: D2699 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Arm Lower Clevis  
 Start Date: 8/08/13 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 8/09/13 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 *130* QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00				26			
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140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				26			1 DAS 05 13-08-14
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150 *150* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3  Memo START TIME: _____ FINISH TIME: _____ OVEN TEMPERATURE: _____	0.00 0.00							
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3200F

10:00

26x ✓ m/f 13/08/15

m126125

1951

Work Order ID 105509

\*105509\*

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August-08-13 7:54:28 AM

Item ID: D2699

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Arm Lower Clevis

Start Date: 8/08/13 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 8/09/13 Rqd Qty: 4.00

\*4\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan: Date: Tooling: Date:

Stop \*NR2\*

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish

0.00

\*160\*

QC

Memo

0.00

Quality Control

26 x 4 11/13/08/15

170 Identify as per dwg & Stock Location: STOCK 0.00

\*170\*

Packaging

Memo

0.00

Packaging

2 x 11/13/08-15

180 QC21- Final Inspection - Work Order Release 0.00

\*180\*

QC

Memo

0.00

Quality Control

13/8/2008

MF  
13-8-16



# Picklist Print

August-08-13 7:54:27 AM

Page 1

Work Order ID: 105509

Parent Item: D2699

Parent Item Name: Arm Lower Clevis

Start Date: 8/08/13

Required Date: 8/09/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C00.11.01Removed P/O for Powder Coat - in house processEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X01.250 6061-T6 Bar .250 X 1.25		Purchased	No			100	f	66.8000	0.3208	1.3507368			

ML25024 → 8.95 A

13.08.10

Location	Loc Qty	Loc Code
MAT049	66.8	
109058	20	
109140	30.3	
10956	16.5	

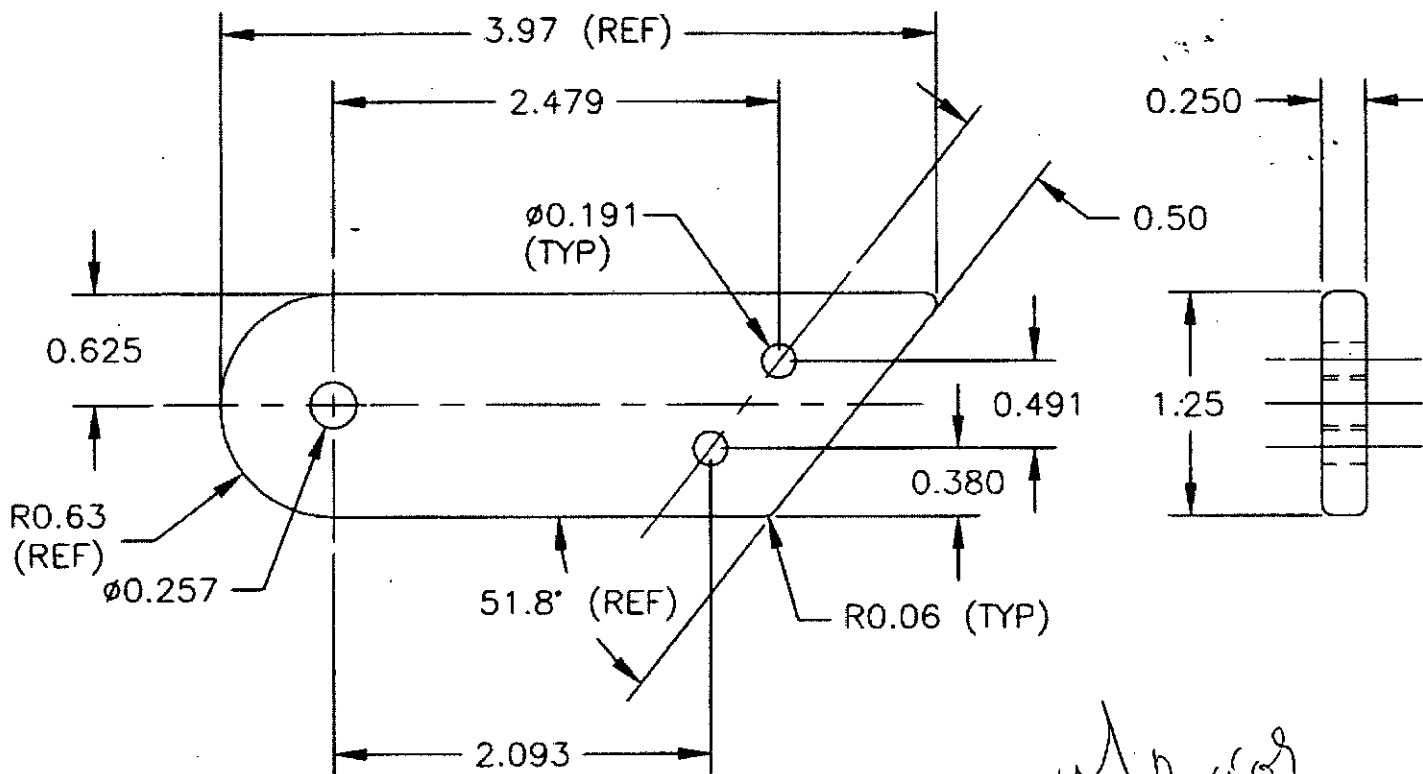
M6061T6  
.250 sheet





**DART****RELEASED**  
99.10.20 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
KE	KE	HARRISBURG, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
UP	[Signature]	D2699	
DATE	TITLE		SCALE
99.10.20	ARM LOWER CLEVIS		1:1
A	97.09.10	NEW ISSUE	
B	99.10.20	UPDATE TOLERANCE AND FINISH	



NOTE: DEBURR ALL EDGES R0.030-R0.060  
MATERIAL: 6061-T6 OR 6061-T651 (QQ-A-225/8  
OR QQ-A-200/8 OR QQ-A-250/11)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





204  
1

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: 13/08/22 Date: 13/08/22QA Closed: 13/08/21 Date: 13/08/21

Work Order: <u>105509</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D2699</u>		Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input checked="" type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
NCR No. <u>13-29104</u>					

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input checked="" type="checkbox"/>	<u>13/8/13</u>	<u>100</u>		<u>φ0.191 holes are oversized from waterjet up to φ0.205", tapered.</u>	<u>CP</u> <u>13/8/13</u>	<u>Acceptable.</u> <u>Ensure there are no ridges from waterjet, Remove if necessary</u>	<u>A2</u> <u>13-08-21</u>	<u>DAS 27 9-89</u> <u>13 &amp; 20</u>	<u>DAS 16 9-89</u> <u>13/08/20</u>
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

## FAULT CATEGORY

Landing Gear	General
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged
<input type="checkbox"/> Crushed/Crimped.	<input type="checkbox"/> Burrs
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio
	<input type="checkbox"/> Grain
	<input type="checkbox"/> Hardware
	<input type="checkbox"/> Inspection Incomplete
	<input checked="" type="checkbox"/> Instructions Incomplete/Unclear
	<input type="checkbox"/> Maintenance
	<input type="checkbox"/> Mislabeled
	<input type="checkbox"/> Misread
	<input type="checkbox"/> Offset
	<input type="checkbox"/> Out of Calibration
	<input type="checkbox"/> Out of Sequence
	<input type="checkbox"/> Outside Dimensions
	<input type="checkbox"/> Ovalized
	<input type="checkbox"/> Over/Under tolerance
	<input type="checkbox"/> Part Incorrect
	<input type="checkbox"/> Part Lost/Missing
	<input type="checkbox"/> Part Moved
	<input type="checkbox"/> Positioned Wrong
	<input type="checkbox"/> Power Loss/Surge
	<input type="checkbox"/> Pressure/Forced
	<input type="checkbox"/> Temperature/Cure
	<input type="checkbox"/> Weld
	<input type="checkbox"/> Wrong Stock Pulled
	<input type="checkbox"/> Other

